

37 1/2 x 68

**Work Order ID 81350****\*81350\***

Page 1

March-13-12 1:36:35 PM

Item ID: D3656-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: PANEL

Stop **\*NS2\***

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/03/13

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3656

Rev B

100

0.00

**\*100\***

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks to fit frame size

x1

Dh  
12/03/20

105

0.00

**\*105\***

Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°FTime IN: 7:00 pm 12/03/19.Time OUT: 5:00 am 12/03/20

x1

Dh  
12/03/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81350

**\*81350\***

Page 2

March-13-12 1:36:35 PM

Item ID: D3656-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: PANEL

Start Date: 13/03/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 27/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 <b>*110*</b> Thermoform Thermoforming Machine	THERMOFORMING MACHINE  Memo Thermoform as per Dwg. D3656-1 and Folio FTA 015 using tool DT 8986Dwg. Rev. <u>B</u> Folio Rev. <u>C</u>	0.00  0.00				<u>x/</u>			<u>DL</u> 12/03/20
120 <b>*120*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo Visually inspect for proper formation of each part	0.00  0.00				<u>x/</u>			<u>DL</u> 12/03/20
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				<u>x/</u>			<u>DL</u> 12/04/17

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81350

**\*81350\***

Page 3

March-13-12 1:36:35 PM

Item ID: D3656-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: PANEL  
 Start Date: 13/03/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 27/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
<b>*140*</b>	HAND FINISHING THERMOFORMING								
Thermoform	Memo	0.00							
Thermoforming Machine	Trim to Finished Dimensions as per dwg D3656								<i>Sh.</i> 12/03/21
150		0.00							
<b>*150*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control	Check dimensions to ensure conformity to drawing tolerances.								<i>Sh.</i> 12/03/21
160		0.00							
<b>*160*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									<i>Scrubuliz</i> <i>Sh.</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81350

**\*81350\***

Page 4

March-13-12 1:36:35 PM

Item ID: D3656-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: PANEL  
 Start Date: 13/03/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 27/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty.	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
<b>*170*</b>									
Packaging	Memo <i>PPR 81335</i>	0.00							<i>12/4/17</i>
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							<i>12/4/17</i>
Quality Control									<i>MF</i> <i>12-04-17</i>

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

March-13-12 1:36:38 PM

Page 1

Work Order ID: 81350

\*81350\*

Parent Item: D3656-1

\*D3656-1\*

Parent Item Name: PANEL

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev. A 07/12/13 New issue DL verified by:DD

IPP Rev. B 08/09/25 Dwg. Update DL.

IPP Rev. C

Add Sstep 105 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,585.990	32	32			

\*MI FXS 093-F6006-07\*

GE PLASTICS LEXAN SHEET

\*\*

## Location

## Loc Qty

## Loc Code

therm

1585.99

112176

40.44

114459

1545.55

32 sf ft

12/03/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	81350
<b>Description:</b> Panel		<b>Part Number:</b>	D3656-1
<b>Inspection Dwg:</b> D3656	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Free of visual flaws (bumps, cracks, voids, etc.)	✓			

**Measured by:** DL      **Date:** 12/03/20

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070	Min	0.073"	✓		CAL TH-DT	
0.050	Min	0.050"	✓		CAL TH-DT	
24.7	REF	24.75"	✓		TAPE TH-05	
0.7	REF	0.73"	✓		VERN DL-02	

**Measured by:** DL      **Date:** 12/03/21

**Audited by:** B      **Date:** 12/04/12

**Prototype Approval:** N/A      **Date:** N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DL	
B	09.09.15	Dimensions updated per Dwg Rev B	KJ	

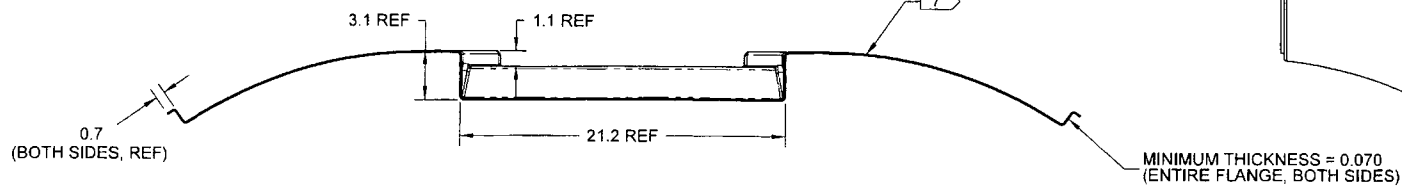
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

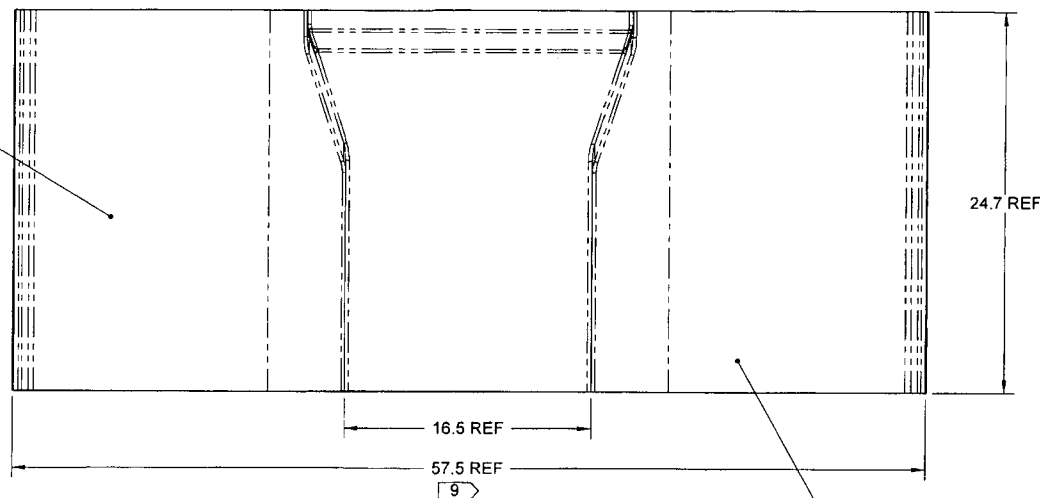
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 81350 MCV  
12/03/13

TEXTURED SURFACE  
ON THIS SIDE



**D3656-1 PANEL**

MINIMUM THICKNESS = 0.050  
(ALL OVER EXCEPT WHERE NOTED)

**RELEASED**  
08-09-30 11:10

**NOTES:**

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK  
(REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022  
TRIM PER DT8986
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 6.6 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

B	REMOVE SKYLIGHT CUTOUTS, UPDATED NOTE 2 (A6-2); REASON: EASE OF MANUFACTURE AND CUSTOMER REQUEST	PH	08.09.18
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PA		
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.	PA	D3656	SHEET 1 OF 2
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	PANEL	NTS
DATE	08.09.18	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

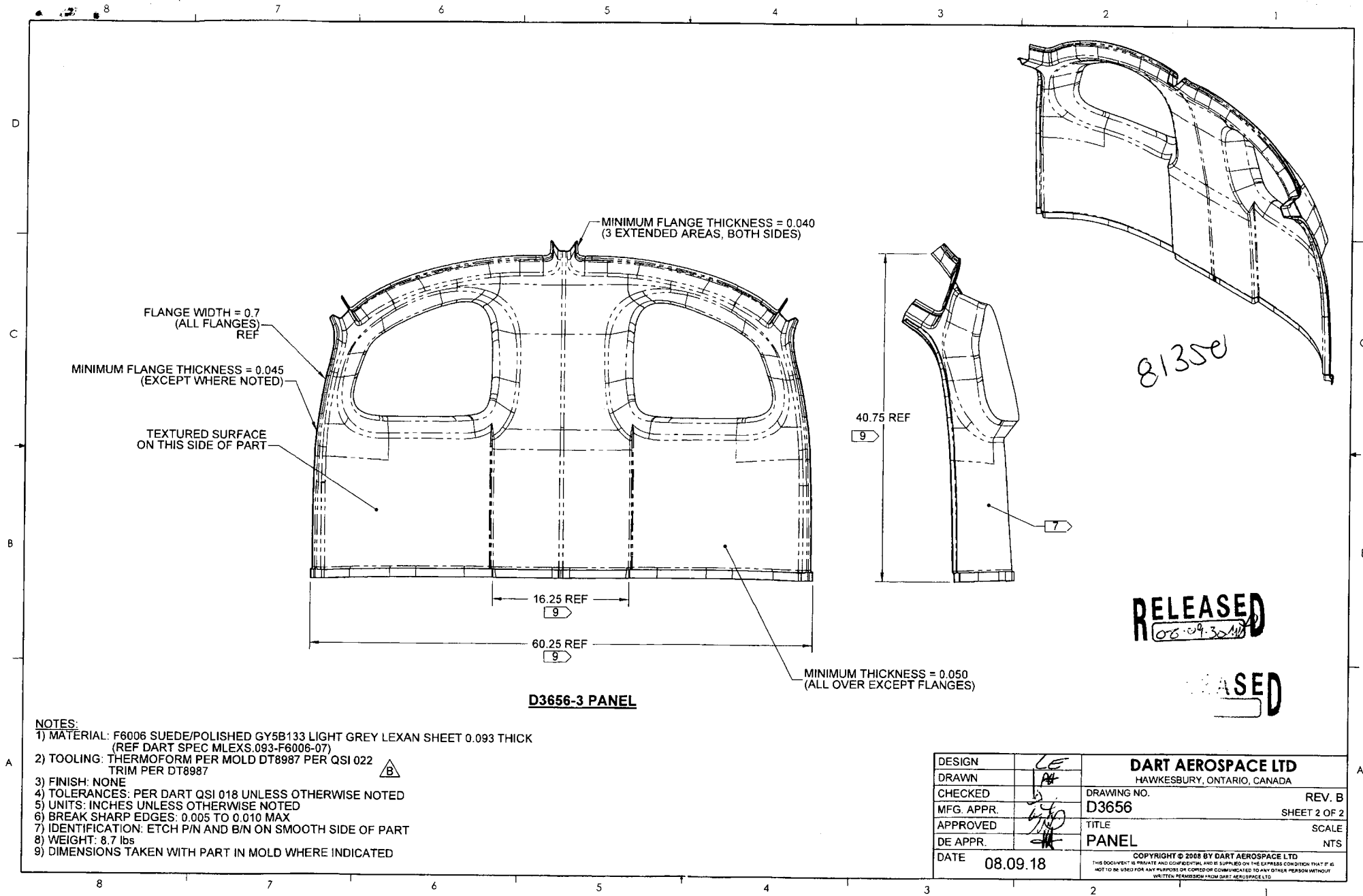
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D3656-3 PANEL

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8987 PER QSI 022 TRIM PER DT8987
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 8.7 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO.	REV. B
MFG. APPR.	54	D3656	SHEET 2 OF 2
APPROVED	54	TITLE	SCALE
DE APPR.	54	PANEL	NTS
DATE	08.09.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries